

Date: Thursday, 25/01/2007 8:34:46 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 L WEB			
Job Number	: 30445		Part Number	: D26545			
Estimate Number	: 11770		Drawing Number	: D2654 REV E			
P.O. Number	: N/A		Project Number	: N/A			
This Issue	25/01/2007	S.O. No.	: N/A		Drawing Revision	: E	
Prsh Rev.	: NC		Material	: N/A			
First Issue	: N/A		Due Date	: 01/02/2007			
Previous Run	: 29779		Qty:	4	Um: Each		
Written By	:		Comment	: Est Rev D 99.02.04 Fixed typo, Changed procedure DM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26007125	Extrusion 'I Beam' thick
Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2600-7- 125 Web 1321130		
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-7 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654 3-Using the uni-bit, open holes to finish size as per Dwg D2654 4-Deburr holes and ends		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D26545 PAR #: K1A Fault Category: Prod/Landing Gear NCR: Yes No DQA: SD Date: 07/02/01  
 QA: N/C Closed: SD Date: 07/02/01

NCR: <u>30445</u>		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
07/01/31	20	<u>Holes were cut to 94.07</u> <u>instead of 94.7. Employee</u> <u>read measurement wrong.</u> <u>Holes will be to close to the</u> <u>end of the web.</u>	<u>Q51042</u>	<u>Scrap. destroy qty 4</u> <u>Replace. Ensure to</u> <u>double check measurement</u> <u>before cutting</u>	<u>JD</u> <u>7/13/1</u>	<u>2</u> <u>07-01-31</u>	<u>Q51042</u>	<u>JD</u> <u>07/01/31</u>	

NOTE: Date & initial all entries

Date: Thursday, 25/01/2007 8:34:46 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 30445

Part Number: D26545

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION <i>PM 07-01-31 4</i>
6.0	PACKAGING 1	PACKAGING RESOURCE #1 <i>PM 07-01-31 4</i>
7.0	QC21	FINAL INSPECTION/W/O RELEASE <i>PM 07-02-01 4</i>

Job Completion



*U 020201*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



copy 1/3  
0355

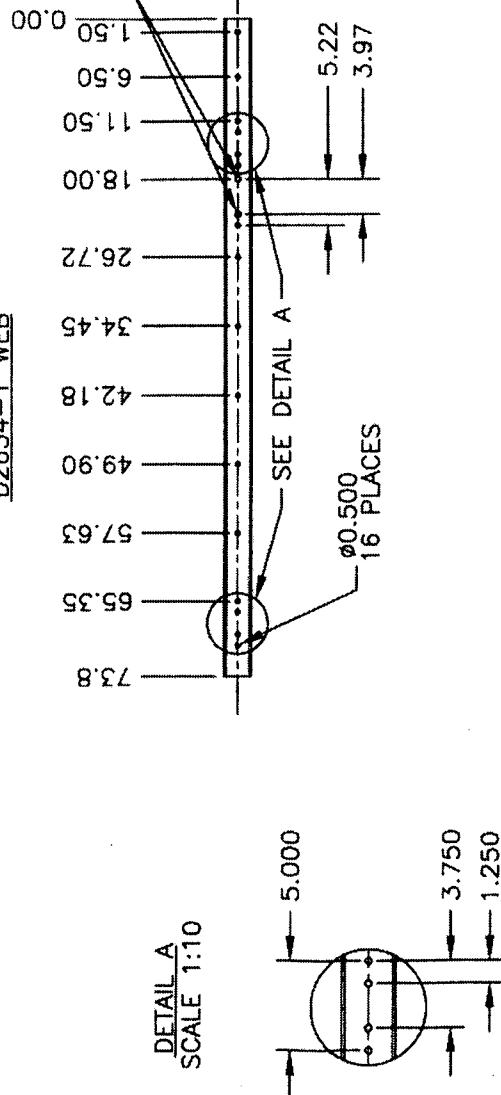
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. REV. E D2654
DATE		SHEET 1 OF 2
04.05.26		TITLE WEB

SCALE 1:20

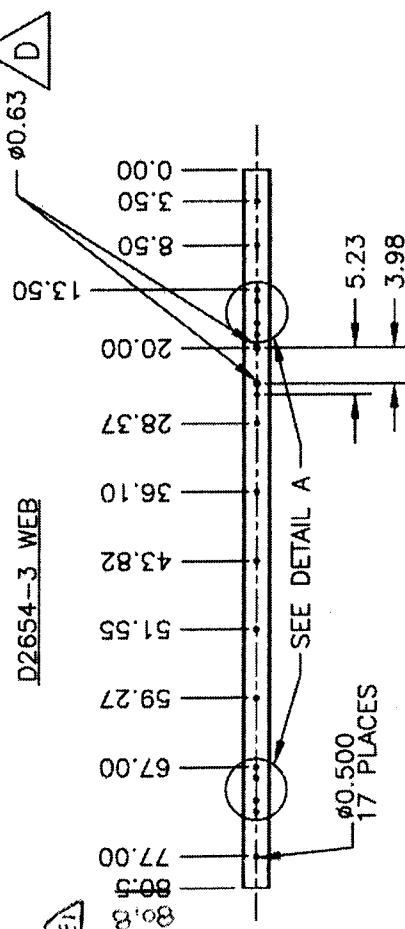
A 97.03.25 NEW ISSUE  
 B 97.06.26 ALTER HOLE PATRN., 0.500 WAS 0.438  
 C 97.10.29 CHANGED HOLE PATTERN  
 D 98.01.15 GHW HOLES CHANGED TO  $\phi$ 0.63  
 E 04.05.26 CHANGE LENGTHS, REFORMAT  
 E1 04.08.04 PER TOOLING; 80.8 WAS 80.5

RELEASED  
04.06.22

D2654-1 WEB



D2654-3 WEB



MAKE FROM D2600-5-108 EXTRUSION  
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

304.45

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED  
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:

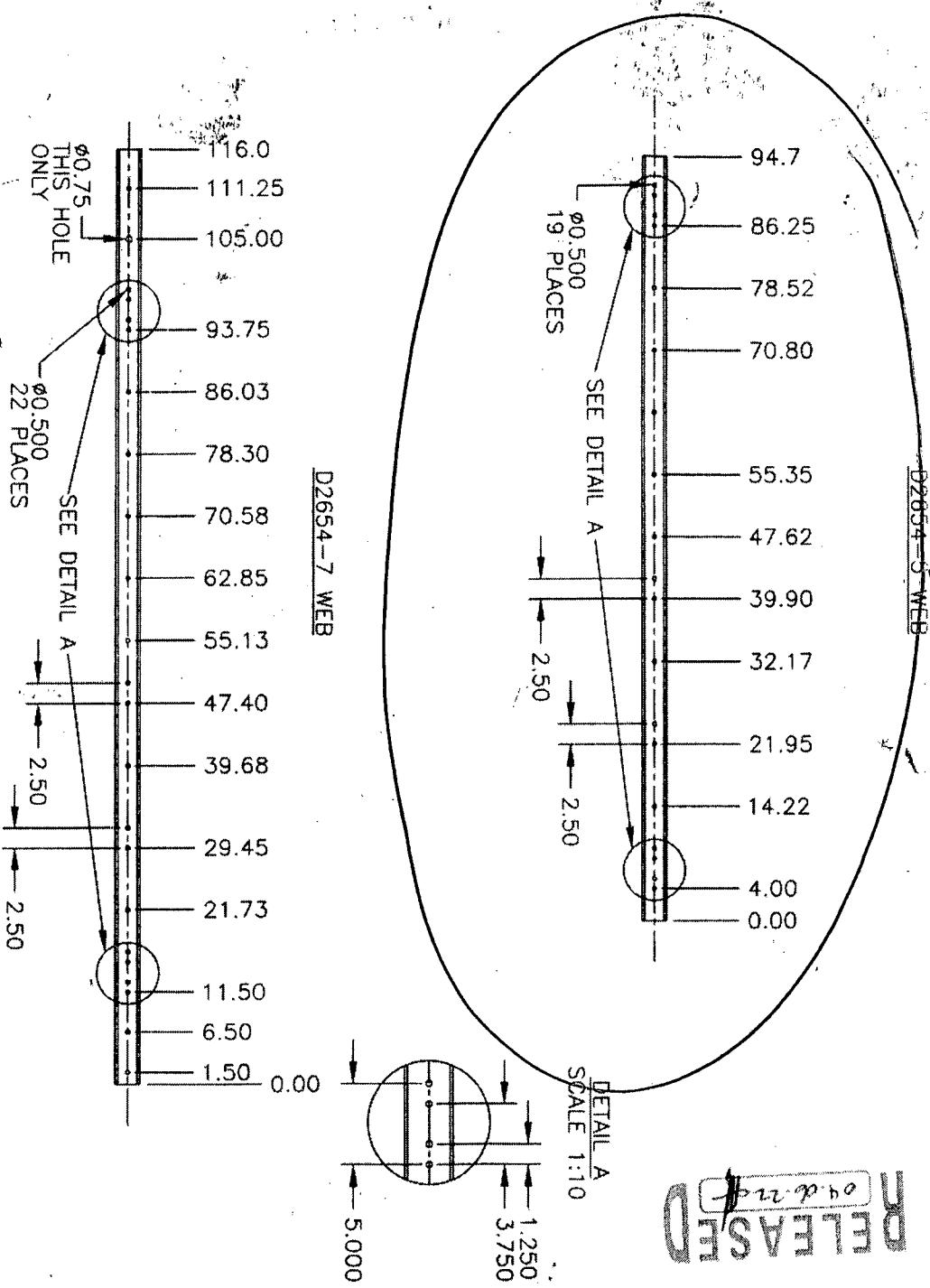
## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date &amp; initial all entries



MAKE FROM D2600-7-125 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	APPROVED	DATE	TITLE	SCALE
REV. E	REVIEWED	D2654	04/05/26	WEB	1:20

DET 2 OF 2



RELEASED

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No:

PAR #:

Fault Category:

NCR: Yes No

DQA:

Date:

QA: N/C Closed:

Date:

NCR:

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date &amp; initial all entries